

Date: Wednesday, 03/09/2008 10:25:46 AM  
User: Julie Lecocq

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
<b>Job Number</b> : 41712	
<b>Estimate Number</b> : 10831	
<b>P.O. Number</b> :	<b>Part Number</b> : D29321
<b>This Issue</b> : 03/09/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2932 REV C- BLUE
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 41128	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 26/09/2008 <b>Qty:</b> 3 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.9.03</u>	
<b>Comment</b> : Est: B 00.06.26 New DWG rev, (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)  
7075-T7351 2X6.25X7.875  
Issue material from stock:  
7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length  
Batch No: B33792

ml 08/09/05

3

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
Program part number and batch number.  
1-Inspect part number and batch number are programmed correctly.  
2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet  
3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet  
4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet  
5-Deburr & TUMBLE

ml 08/09/06

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
Machine Keyway and inspect per attached dimension sheet

SS 08/09/08

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

SS 08/09/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 10:25:46 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 41712

Part Number: D29321

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/09/07 (3)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL

08-09-08

(X3)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B 106729

-SPRAY PAINT DELFLEET BLUE

B 105918

-CLEAR DELFLEET

B 105717

ET 08-09-12 (3)

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

08-09-11 (3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

-Location: 445

08/12

(X3)

SL

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/15

Job Completion



MF 08-09-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 41712
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

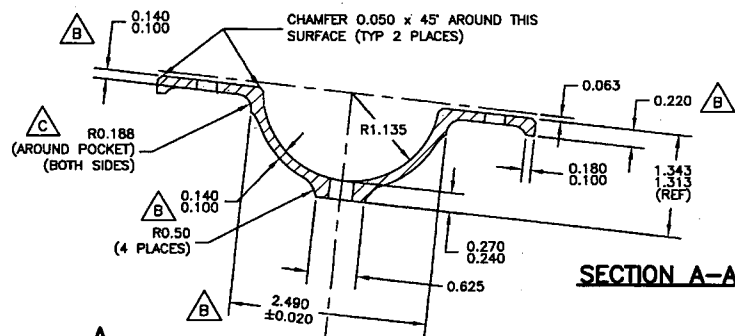
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.118	.117	.115			
B	0.100	0.140		.118	.115	.118			
C	0.100	0.140		.124	.124	.123			
D	0.210	0.230		.218	.219	.219			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.510	.510	.510			
I	1.572	1.582		1.577	1.578	1.578			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.258	.258	.258			
L	0.312	0.317		.318	.317	.317			
M	0.235	0.240		.238	.238	.238			
N	0.100	0.140		.122	.122	.122			
O	0.540	0.560		.545	.540	.545			
P	0.490	0.510		.505	.505	.505			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.470	2.510		2.492	2.490	2.491			
S	0.240	0.270		.250	.250	.250			
T	0.100	0.180		.140	.140	.140			
U	1.625	1.635		1.630	1.630	1.630			
V	1.362	1.372		1.370	1.370	1.370			
W	0.316	0.321		.321	.321	.321			
X	1.125	1.145		1.137	1.135	1.135			
Y	1.565	1.585		1.571	1.570	1.570			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>S.F.</i>
Date: 05/09/06

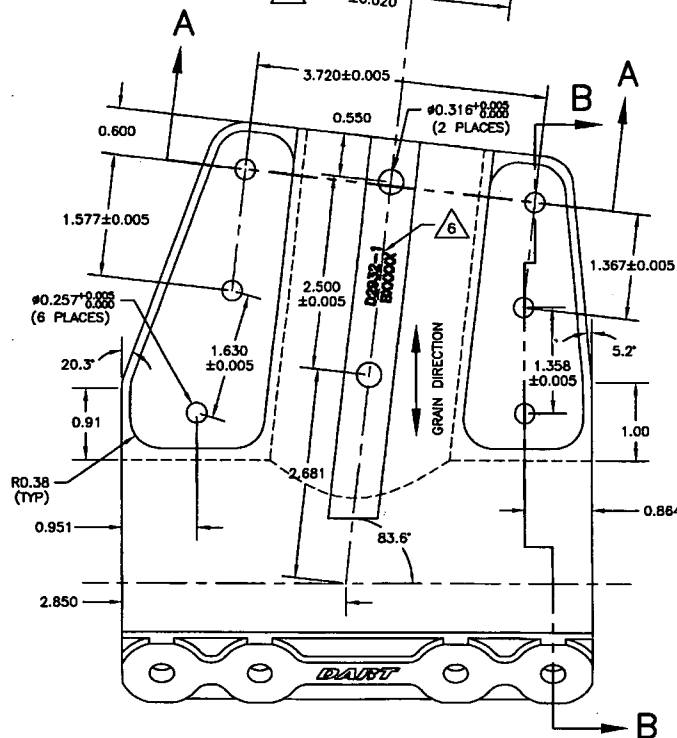
Audited by: <i>J.F.</i>
Date: 08/09/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

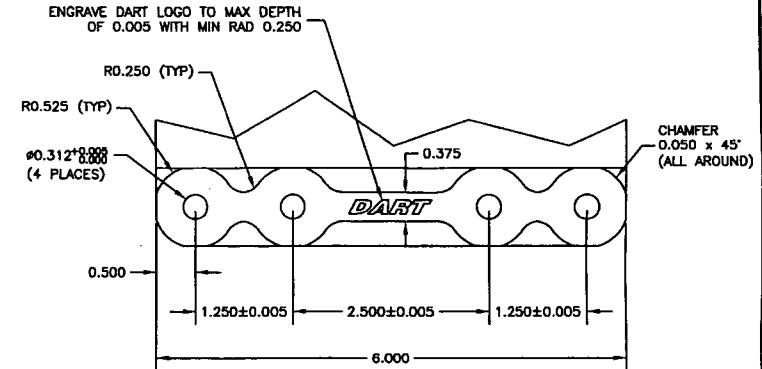
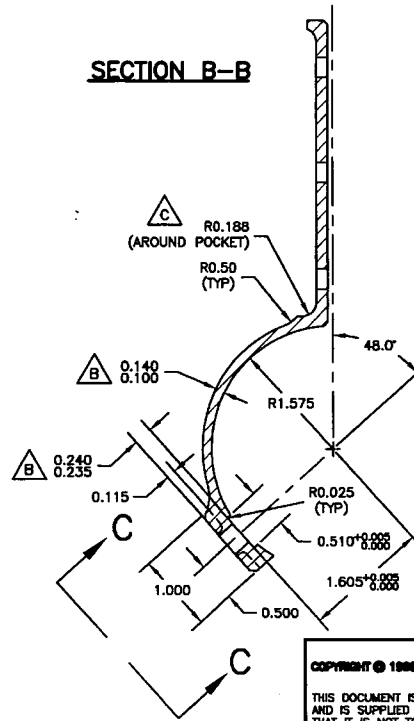
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WORK ORDER  
NO. 41712



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (Q0-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2932
DATE		TITLE SADDLE OUTSIDE
06.11.09		SCALE 2:3

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